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Hawkesbury, ON
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D412-742-043
Job Sheet 187411



Part No: D412-742-043

Job Qty: 1 ea

Part Name: Repl. Skidtube Fits LH or RH, High Gear, DART (Apical) Tri-Bag Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/4/18

Job Tracking No:

Due Date: 1/29/19

Created By: Jesse White

Type: Stock

Description:

Note: DWG D3391-043 REV J SHEETS 1,2 IPP Rev A 05.10.13 New Issue KJ/JLM IPP Rev 06.02.13 ECN 773 dwg @ rev.D EC IPP Rev:C 07-05-28 As per Rev F JLM IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC IPP Rev:F 11.11.01 as per DSI9517 REV.B DD verified by:EC IPP REV:G 16.05.02 AS PER DWG REV.J DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/29/19	1/29/19	0.00	0.00	Start Up Container		
110	HandFinish	1 pcs	1/29/19	1/29/19	0.00	3.50	HandFinish4		
120	QC	1 pcs	1/29/19	1/29/19	0.00	0.00	QC5		
130	Packaging	1 pcs	1/29/19	1/29/19	0.00	0.00	Packaging3-2		
135	DC	1 pcs	1/29/19	1/29/19	0.00	0.00	DC		
140	QC21-FG	1 Ea	1/29/19	1/29/19	0.00	0.00	QC21		

Part Op 110 - 1-Install tubes together and seal them all the way around using Sikaflex 241/291. Ensure tube ends line-up with Descriptions: saddle holes for proper alignment. using 7/16" "T" Pins. A/R Sikaflex-241/291 5163437 Expiry date: 19-12-9 2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against wearplate, then topped with the SS washer. Seal all bolts with sikaflex except ones with inserts on inside of tube ,hand tighten only bolts with no sikaflex. A/R Sikaflex-241/291 5163432 Expiry date: 19-12-9 3-Remove "T" pins once sikaflex is dry. 4-Coat all exposed hardware with LPS Procyon. Remove any excess off with MEK degreaser. A/R LPS Procyon M133690 VERIFY FWD AND AFT SADDLE FIT DURING ASSEMBLY BY: DATE: 19-06-10

130 - Identify and pack for shipping as per PPP D412-742-043 Location: PPP Rev:

135 - If D412-742-043 is a W/O on it's own, Photocopy bluefile and create labels per PPP D412-742-043 CHG007

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C4A	Bolt	24 Ea (24 ea)	90-Start up Operation	5143675
AN3C6A	Bolt	4 Ea (4 ea)	90-Start up Operation	5174235
AN5C7A	Bolt	10 Ea (10 ea)	90-Start up Operation	5079115
D3391-021	Fwd Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5136561
D3391-023	Mid Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5155255
D3391-025	Aft Tube Assembly	1 Ea (1 ea)	90-Start up Operation	5137308
D4095-041	Wearplate Fwd	1 Ea (1 ea)	90-Start up Operation	5072731
D4095-043	Wearplate Aft	1 Ea (1 ea)	90-Start up Operation	5059955
D4095-045	Wearplate Center	1 Ea (1 ea)	90-Start up Operation	5041025
NAS1149C0332R	Washer	28 Ea (28 ea)	90-Start up Operation	5086678
NAS1149C0532R	Washer	10 Ea (10 ea)	90-Start up Operation	5014735

5188786

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3C4A	24	1,647	0
	AN3C6A	4	159	0
	AN5C7A	10	144	0
	D3391-021	1	2	0
	D3391-023	1	2	0
	D3391-025	1	4	0
	D4095-041	1	12	0
	D4095-043	1	12	0
	D4095-045	1	9	0
	NAS1149C0332R	28	3,437	0
	NAS1149C0532R	10	402	0

Part Specifications

Specifications could not be found.

Plex 12/4/18 10:32 AM dart.white.jesse

DART
 AEROSPACE

Container No: S188786



Part: D412-742-043

Job No: 187411

Serial No/Batch: S188786

Revision: A/J

Inspector:

Exp Date:

Instructions: FAA STC SR01583SE 18/10/17, TC STC SH05-

 1270 Aberdeen Street
 Hawkesbury, ON K64 1K7
 CANADA
 TEL: 1 613 632-6200
 Email: sales@dartaero.com
 www.dartaerospace.com

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

5.2 D412-742-013 (DART TRI-BAG) Float Skidtube Installation Parts List

Item	Qty -013	Qty -043	Part Number	Description
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE
		1	D3391-043	412 FLOAT SKIDTUBE
1		*24	*AN3C4A	*BOLT
3		*10	*AN3C6A	*BOLT
4		*4	*AN3C7A	*BOLT
5		*38	*AN960C10L	*WASHER
21		*1	*D4095-041	*WEARSHOE (REPLACES D3564-1)
22		*1	*D4095-043	*WEARSHOE (REPLACES D3564-3)
23		*1	*D4095-045	*WEARSHOE (REPLACES D3564-5)
10		*1	*D3391-021	*412 FORWARD TUBE
11		**1	**D3401-041	**TOW CAP
12A		**10	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB166)
13		**10	**AN3C4A	**BOLT
14A		**4	**D3672-1	**WASHER (REPLACES NAS1515H3L)
14B		**10	**AN960C10L	**WASHER
24		**1	**D4095-051	**WEARSHOE (REPLACES D3564-13)
20		*1	*D3391-023	*412 MID TUBE
28		**20	**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB116)
30		*1	*D3391-025	*412 AFT TUBE
25		**1	*D4095-049	**WEARPAD (REPLACES D3537-1)
26		**1	*D4095-047	**WEARPAD (REPLACES D3537-7)
31		**1	**D2646	**AFT CAP
32		**14	**AELS-1032-130	**INSERT
36		**8	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB366)
37A		**6	**AN3C4A	**BOLT
37B		**4	**AN3C5A	**BOLT
38A		**2	**D3672-1	**WASHER (REPLACES NAS1515H3L)
38B		**10	**AN960C10L	**WASHER

(CONTINUED ON PAGE 22)

Change Record

PAGE 1 OF 1

Part Number: D412-742-043

Description: REPLACEMENT FLOAT SKIDTUBE[illegible]